

Date: Wednesday, 23/07/2008 11:28:36 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)
Job Number	: 40718		
Estimate Number	: 10258		
P.O. Number	:	Part Number	: D2332041
This Issue	: 23/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2332
First Issue	: / /	Project Number	: N/A
Previous Run	: 39332	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 30/07/2008
Checked & Approved By	: <u>JLD 08.7.23</u>	Qty:	27
Comment	Est: B 02.08.12 Re-format; Incorporated D2332-13/11/71-5 KJ/ RF		
	Est Rev: C- 08-06-02 add comment DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000WO49	304 RD Tube 1.00 x .049W
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Comment: Qty.: 0.4331 f(s)/Unit Total: 11.6944 f(s)
 Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch M108756

EP 08/08/11

Batch

2.0	M304R250	304 SS Round bar .250
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Comment: Qty.: 0.1092 f(s)/Unit Total: 2.9484 f(s)
 Material: Ø0.250" 304SS Rod
 Batch M107389

EP 08/08/11

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

3

EP 08/08/11

(28)

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2502 f(s)/Unit Total: 33.7554 f(s)
 304 RD Tube .500 x .035W

M108215 (28) M107166 (5X)
M107967 (11X) M107403 (13X)

EP 08/08/11 (28)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 08/08/12

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)
2-ensure no foreign objects inside fo tube and deburr

SB 08/08/11

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/13

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)
***** insure nothing is inside of tube before welding*****

L 28

A/R SS Rod Batch: M107057
*****brush weld right after welding, to take color off*****

L2 8-8-19

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-20

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

SB 08/08/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041* PAR #: N/A Fault Category: Proced/Lng Sub NCR: Yes No DQA: 11 Date: 08.08.22
D350-607 welding. QA: N/C Closed: 11 Date: 08/08/22

NCR: <u>40718</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8/8/20</u>	<u>#100</u>	<u>During inspection 2 parts</u> <u>were found with forgive</u> <u>parties inside.</u> <u>2.c. parts were not checked</u> <u>100% inside</u>	<u>[Signature]</u>	<u>SCRAP and Destroy</u> <u>no replace qty <u>(X)</u></u> <u>D2332-13</u>	<u>EL</u> <u>8.8.20</u>	<u>S</u> <u>08/08/20</u>	<u>[Signature]</u>	<u>S</u> <u>08/08/20</u>

NOTE: Date & initial all entries

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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 27.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4-4A	Bolt

Batch

M106918

08/08/21

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 81.0000 Each(s)

Pick:

Qty	Part Number	Description
3	AN960JD416L	Washer

Batch

M108583

08/08/21

14.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 27.0000 Each(s)

Pick:

Qty	Part Number	Description
1	MS21042L4	Nut (or -4)

Batch

M107499

08/08/21

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/21 *counted* **(x26)**

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51203

08/08/21

(x26)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



mt 08-08-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

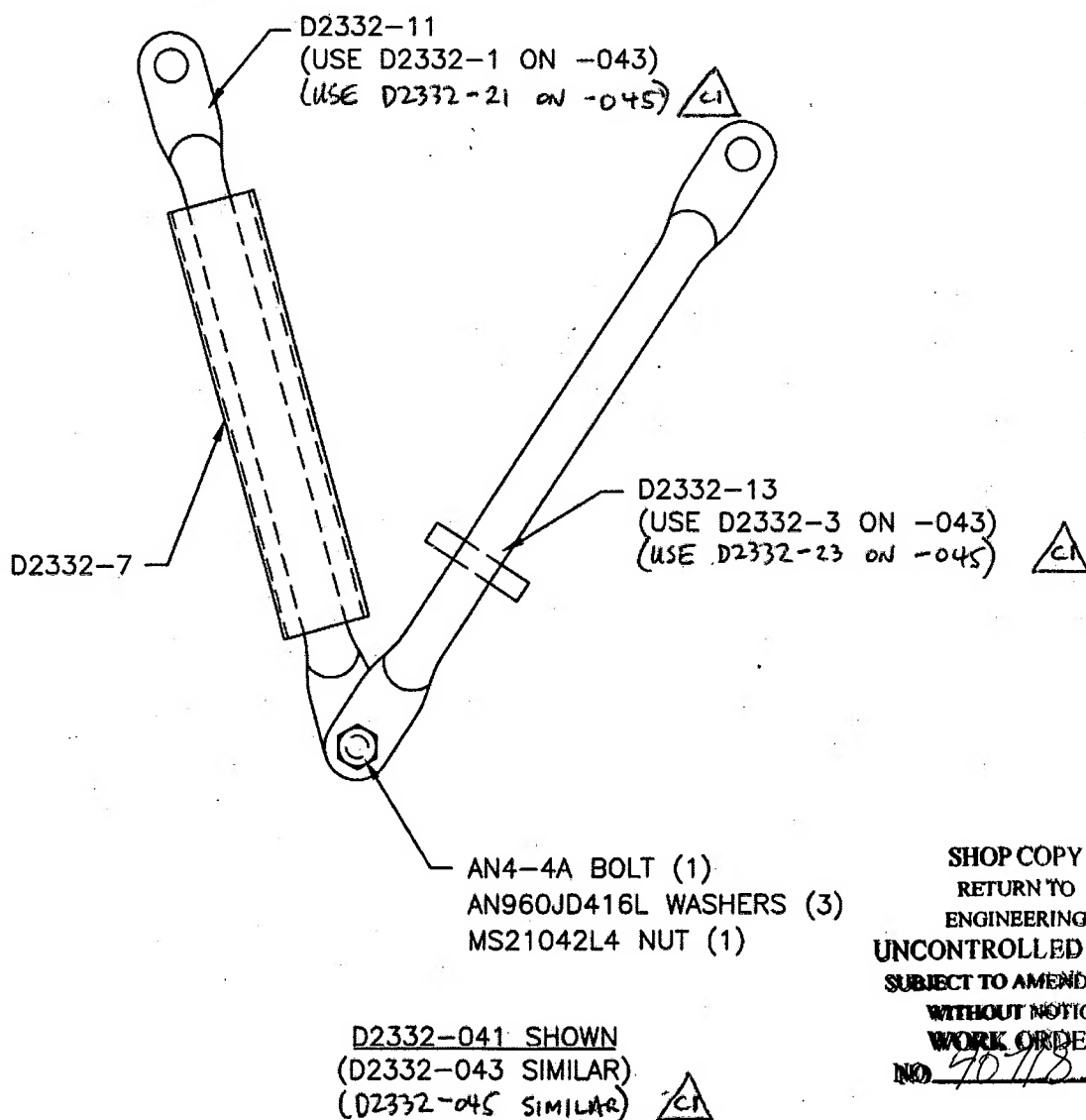
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	# 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



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WORK ORDER
NO 90718

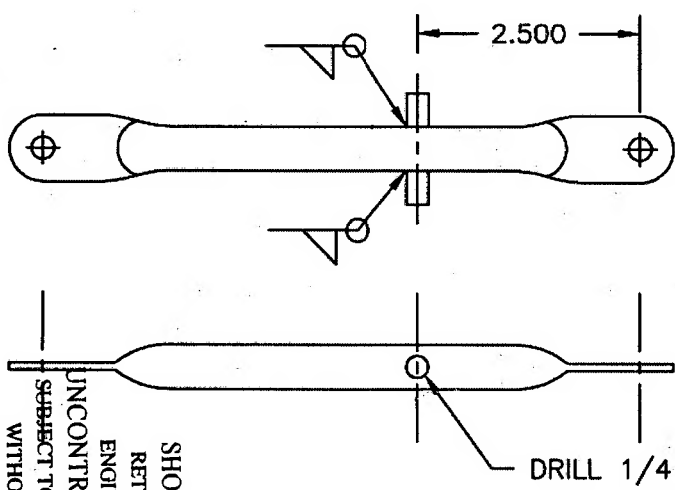
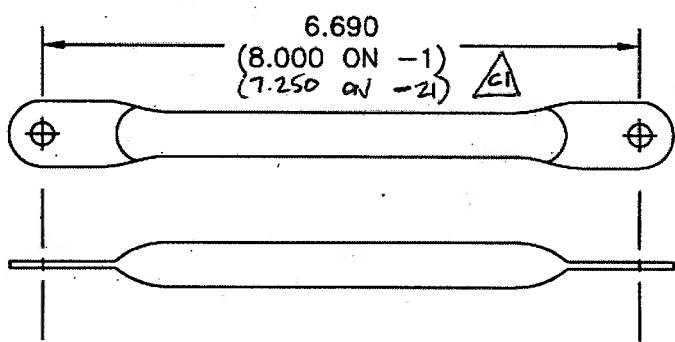
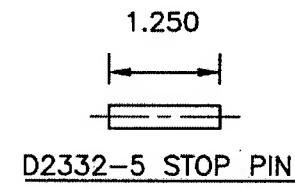
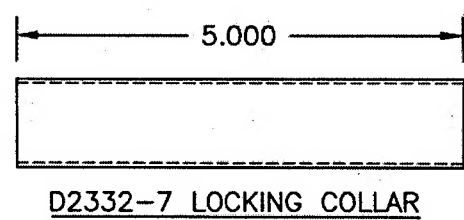
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DART

ISSUED TO

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE -011 PROP 6.61" LONG (END)
C1	03.08.06	MAKE -043 PROP 8.00" LONG (END)
		ADD -045 PROP (7.25" LONG)



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NO. 40718

M/F D2332-11 & D2332-5
D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

- NOTES:
- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
 - TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04